

## AMENDMENTS

### In the Claims:

1. (Currently Amended) A production machine comprising associated machine components including a drive, a control unit for controlling said drive, and detectors for determining at least two a first and a second variables fed to said control unit which are generated during the operation of the machine, wherein the control unit comprises a first~~positional~~-setpoint determination unit receiving said first variable for generating a first setpoint, a second~~correctional~~-setpoint determination unit receiving a first internal variable derived from said first~~second~~-variable and a setpoint for generating an intermediate setpoint, wherein the intermediate setpoint is corrected by said second variable to generate a second setpoint and a machine control unit receiving said first and second~~positional~~-setpoints and said ~~correctional~~ setpoint for generating a machine control parameter, wherein ~~said correctional setpoint determination unit generates a first and second correctional setpoint depending whether a threshold of the first variable is exceeded.~~
2. (Original) A production machine according to claim 1 wherein the drive is selected from the group consisting of hydraulic, electric and a combination of hydraulic and electric.
3. (Currently Amended) An injection molding machine for the manufacture of plastic parts comprising an motor driven advancing screw for driving the injection and generating an injection pressure, said machine further comprising means for detecting and registering the injection pressure and position of said screw as measured variables during operation, ~~said screw having and control means generating a first setpoint at least one from said position variable by a speed/displacement profile variable and a first intermediate first and second pressure variable from said position variable by a pressure profile variable wherein said first intermediate pressure variable is corrected by said pressure variable to generate a second setpoint, wherein said first and second setpoint are fed to a machine control unit for generating a motor control parameter for said motor the at least one speed/displacement profile variable determines a setpoint value which can be counteracted by~~

~~said first or second pressure profile variable depending on whether said position exceeds a predetermined threshold position.~~

4. (Withdrawn)

5. (Withdrawn)

6. (Previously Presented)The production machine according to claim 1 wherein the drive advances a screw for driving an injection and generating an injection pressure, and wherein the first variable is a position of said drive and the second variable is said injection pressure.

7. (Currently Amended)The injection molding machine according to claim 3 wherein the first pressure profile is pressure/displacement profile ~~and the second pressure profile is a pressure/time profile~~.

8. (Currently Amended)The injection molding machine according to claim 7 wherein the speed/displacement profile and/or the pressure profile[s] can be predetermined.

9. (Withdrawn)

10. (Currently Amended)A method for the open-loop control of a production machine comprising the steps of:

- determining a ~~positional~~first setpoint from at least a first variable ;
- determining a ~~correctional~~an intermediate setpoint from a ~~second~~ a first internal variable ~~derived from said first variable~~ and either a ~~first or second~~ setpoint depending whether a threshold of the first variable is exceeded,
- correcting said intermediate setpoint with a second variable to generate a second setpoint; and
- generating a machine control parameter from said ~~positional~~first setpoint and said ~~correctional~~second setpoint.

11. (Currently Amended)The method according to claim 10, wherein the ~~positional~~first setpoint is determined by a speed/displacement profile, and the first internal

~~variable setpoint~~ is determined by a pressure/displacement profile, and the second setpoint is determined by a pressure/time displacement.

12. (Withdrawn)

13. (Withdrawn)

14. (Canceled)

15. (Canceled)

16. (Canceled)

17. (Canceled)

18. (Withdrawn)

19. (Currently Amended) A production machine according to claim 1, further comprising a further detector for determining a third variable, wherein the ~~correctional~~ ~~second~~ setpoint determination unit comprises a first ~~setpoint determination~~ unit receiving said ~~first~~ for generating said first internal variable, and a second setpoint determination unit receiving for generating a second internal variable from said a third variable, and a select unit controlled by said threshold derived from said first variable for selecting said first or second internal variable for generating said intermediate setpoint as said setpoint.

20. (Currently Amended) A production machine according to claim 19 further comprising a subtraction unit for subtracting said second variable from said selected first or second internal variables ~~setpoint~~ and a function unit for generating said second ~~correctional~~ setpoint receiving an output signal from said subtraction unit.

21. (Previously Presented) A production machine according to claim 20 wherein the select unit further selects a first or second parameter set which is fed to said function unit.

22. (Previously Presented)The production machine according to claim 1 further comprising a mold, wherein the drive positions said mold and wherein the first variable is a position of said mold and the second variable is a mold closing pressure.

23. (Previously Presented)The production machine according to claim 1 further comprising an ejection mechanism, wherein the drive controls an ejection and wherein the first variable is a position of said ejection mechanism and the second variable is an ejecting force.

24. (Currently Amended)The method according to claim 11 wherein the first variable is the position of a mold and the positional first setpoint is a function of the closing/opening speed and the second variable is a opening and/or closing pressure of the mold.

25. (Currently Amended)The method according to claim 11 wherein the first variable is the position of an ejection mechanism of a mold, the positional first setpoint is a function of the speed of the ejection mechanism and the second variable is an ejection force of the ejection mechanism.

26. (NEW)The method according to claim 10, further comprising the steps of:

- generating a second internal variable from a third variable;
- selecting either said first or second internal variable depending on a threshold derived from said first variable; and
- subtracting said second variable from said selected first or second internal variable to generate said second setpoint.

27. (NEW)The method according to claim 26, further comprising the step of feeding said subtracted variable to a function unit for generating said second setpoint.

28. (NEW)The method according to claim 26, wherein said function unit is controlled by a parameter and wherein the parameter is selected by said threshold.

29. (NEW) The injection molding machine according to claim 3, further comprising a further detector for determining a time variable, wherein the control means comprise a first unit for generating said first intermediate pressure variable and a second unit for generating a second intermediate pressure variable from said time variable, and a select unit controlled by a threshold

derived from said position variable for selecting said first or second intermediate pressure variable for generating said intermediate setpoint.